

Work Order ID 63318

Wednesday, October 27, 2010 3:00:09 PM



Page 1

Item ID: D2022-101

Accept



Setup Start



Revision ID:

Stop



Item Name: Spacer

Start Date: 10/27/2010 Start Qty: 80.00



Cust Item ID:

Required Date: 11/11/2010 Req'd Qty: 80.00



Customer:

Reference:

Approvals:

Process Plan:

R

Date:

10/27

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

100

0.00



Hardinge

Hardinge CNC Lathe Small

Memo

0.00

Note: .257" dia drill

1-Turn as per folio FA206 & dwg

FOLIO REV: *11/1*

DWG REV: *10/11/12*

2-Deburr as required

81 *Ø*

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

SA 10/11/12

81 *Ø*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				81			
130 Packaging Packaging	Identify as per dwg & Stock Location: <u>509</u> Memo	0.00 0.00							<u>10/11/12</u> (FL)
140 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<u>10/11/15</u> (J) <u>10-11-12</u> (81)

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Picklist Print

Wednesday, October 27, 2010 3:00:47 PM

Page 1

Work Order ID: 63318

Parent Item: D2022-101

Parent Item Name: Spacer



Start Date: 10/27/2010

Required Date: 11/11/2010

Start Qty: 80.00

Required Qty: 80.00

Comments: IPP ☐ D02.03.07 ☐ Now made in house ☐ NG ☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.750		Purchased	No			100	f	22.3648	0.03	2.4			

6061-T6 Round Bar .750"

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT	22.348	
115469	0.0027	
115869	22.3453	
MAT012	0.016842105	
112442	0.01684211	

2.4 ft s/a 10/11/12

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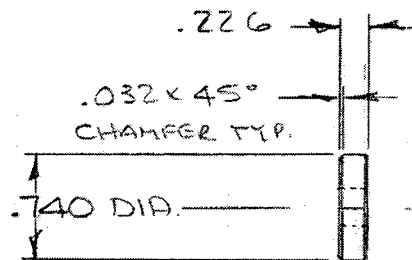
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D2022-101
D2022-103

SHOT COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 633E

D10-10-27

RELEASED
970119 BW

DRILL 'F' (.257) DIA. IN -101
DRILL P (.323) DIA IN -103

MAT'L: ALUMINUM 6061-T6 (QQ-A-225/B)



D2022

D2022-103		SPACER 5/16 ALUM 6061-T6		QQ-A-250/B	
D2022-101		SPACER 1/4 ALUM 6061-T6		QQ-A-250/B	
PART NO.		ITEM	DESCRIPTION	MATERIAL	SPEC/VENDOR
CONTRACT NO.					
DRAWN BRADLEY		DATE 8-15	CLIENT		
DESIGN BRADLEY					
STRESS		TITLE			
CHECKED		SPACERS			
CLIENT		CODE	DWG NO D2022		REV.
		SCALE 1:1	SHT 1 OF 1		

		REVISION		THE DRAWING IS PRIVATE AND CONFIDENTIAL AND IS LOANED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF CHART AERO.		RIVET CODE SHALL BE PER MAS S22	
		DRAWN				BASIC CODE	
		APPROVED				DIA DASH NO HOLE/SLD MARK SET PUNCHED FOR RIDE	
						O-DIMENL DASH/NO OF SHEETS C-COUNT/NO	
		DESCRIPTION		REQUIREMENTS - UNLESS OTHERWISE SPECIFIED		BASIC CODES	
				GENERAL		LHWHN DASH NO UN-EXP/NO	
				1. DIMENSIONS ARE IN INCHES			
				2. SURFACE ROUGHNESS 125			
				3. REPAIRS: BUMP EDGES 0.118 MAX.			
				4. THREADS PER ANSI - B - 17.1			
				5. HOLES PER ANSI 10.1			
				1. TOLERANCES - SEE 1.000			
				2. ANGLES - 30:1			
				3. PARALLELISM - 1/16"			
				4. PERPENDICULARITY - 1/16"			
				5. SYMMETRY - 1/16"			
				6. ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED			
		OF					
		CHANGE				BUSHING/NO BUSHING/NO	
</							

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